

Work Order ID 78660

January-12-12 9:31:43 AM

78660

Page 1

Item ID: K10111 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Skidtube 206
 Start Date: 12/01/2012 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 02/02/2012 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/01/12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9583	A								
K10111	B								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP FOR D206-642-111 CHG007 FOR D206-642-113 CHG002	K10111	CHG003						
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

CHG003

MLJ 12-1-13

12/01/12

12/1/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 78660

78660

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 12/01/2012

Required Date: 02/02/2012

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP: F01.11.08 Revised Step 5 and Added Inspection Level

21SM

IPP REV:G

11.09.23 PER REV.B DD VERF:EC

IPP REV:H 11.11.14

AS PER DSI9583 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
S3 AN3-41A* Bolt		Purchased	No			110	Each	959.0000	8	24			
									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST354			959					
					119042			959					
S3 AN4-6A* Bolt		Purchased	No			110	Each	3,508.000	12	36			
									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST356			3508					
					119017			3508					
S3 AN4C5A* BOLT		Purchased	No			110	Each	399.0000	1	3			
									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					FP002			19					
					112243			19					
					ST355			380					
					112243			280					
					119017			100					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 78660

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Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 12/01/2012

Required Date: 02/02/2012

Start Qty: 3.00

Required Qty: 3.00

AN5-10A Purchased No

110 Each 634.0000

12

AN5-10A

Bolt

**

Location

Loc Qty

Loc Code

ST337

634

118191

80

119547

454

119981

100

Purchased No

110 Each 1,251.000

12

AN5-11A

AN5-11A

Bolt

**

Location

Loc Qty

Loc Code

ST337

1251

118191

13

119512

1238

Purchased No

110 Each 337.0000

2

AN6-44A

AN6-44A

Bolt

**

Location

Loc Qty

Loc Code

ST343

7

119127

7

st510

330

119036

330

Manufactured No

110 Each 25.0000

3

D206-651-041

D206-651-041

206A/B GHW

**

Location

Loc Qty

Loc Code

FG120

25

76578

25

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Shop Packet Print

Page 2

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 78660

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Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 12/01/2012

Required Date: 02/02/2012

Start Qty: 3.00

Required Qty: 3.00

D2652

Manufactured No

110

Each

991.0000

16

48

D2652

Bushing

**

Location

Loc Qty

Loc Code

FG

44

31985

44

ST013

947

73834

15

73836

36

76132

96

~~76133~~

400

77135

400

D2661-1

Manufactured No

110

Each

25.0000

2

6

D2661-1

Saddle, LH Fwd Aft Out 206

**

Location

Loc Qty

Loc Code

MEZZ

7

64559

5

76730

2

ST435

18

76808

8

76809

10

D2662-1

Manufactured No

110

Each

21.0000

2

6

D2662-1

Saddle, LH In 206

**

Location

Loc Qty

Loc Code

ST435

21

76784

3

76804

8

76805

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Saddle, Skidtube 206

Start Date: 12/01/2012

Required Date: 02/02/2012

Start Qty: 3.00

Required Qty: 3.00

D2712

Manufactured No

110

Each

1,642.000

10

30 

D2712

Set Screw

**

Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

1592

76065

1592

30

D2884

Manufactured No

110

Each

367.0000

2

6 

D2884

Saddle Spacer

**

Location

Loc Qty

Loc Code

FG

10

29453

10

ST020

357

76751

357

6

D2885

Manufactured No

110

Each

358.0000

2

6

D2885

Saddle Spacer

**

12/1/13 

Location

Loc Qty

Loc Code

FG

10

29199

10

ST020

348

76752

348

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Saddle, Skidtube 206

Start Date: 12/01/2012

Required Date: 02/02/2012

Start Qty: 3.00

Required Qty: 3.00

D3413-1

Manufactured No

110

Each

59.0000

1

3

D3413-1

Ring

**

Location

Loc Qty

Loc Code

ST420

2

66387

1

70773

1

ST464

55

73822

3

~~75478~~

52

ST473

2

71041

2

MS21042L3

Purchased

No

110

Each

6,081.000

8

24

MS21042L3

Nut

**

Location

Loc Qty

Loc Code

ST300

6081

117441

16

117885

32

118451

5

118927

3

119017

5551

~~119075~~

474

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 12/01/2012

Required Date: 02/02/2012

Start Qty: 3.00

Required Qty: 3.00

MS21042L4

Purchased

No

110

Each

7,825.000

12

36

MS21042L 4

Nut

**

Location

Loc Qty

Loc Code

ST300

7825

117441

67

117601

342

118451

133

119017

2283

119075

5000

36

MS21042L6

Purchased

No

110

Each

1,118.000

2

6

MS21042L 6

Nut

**

Location

Loc Qty

Loc Code

ST300

1118

117677

25

118384

5

118927

48

119075

1000

119736

40

6

NAS1149C0463R

Purchased

No

110

Each

1,280.000

1

3

NAS1149C0463R

Washer

**

Location

Loc Qty

Loc Code

FP001

1

115358

1

ST297

1279

117735

279

119097

1000

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 12/01/2012

Required Date: 02/02/2012

Start Qty: 3.00

Required Qty: 3.00

NAS1149D0363J

Purchased

No

110

Each

3,266.000

8

24

NAS1149D0363.J

**

Washer

Location

Loc Qty

Loc Code

ST298

3266

117601

61

118077

1

118612

18

118968

26

119537

1160

120142

2000

24

NAS1149D0463J

Purchased

No

110

Each

6,584.000

24

NAS1149D0463.J

**

Washer

Location

Loc Qty

Loc Code

ST298

6584

116289

16

116805

0

117291

1

117460

6

118179

42

118384

170

118612

3

119042

11

119075

6166

~~119097~~

169

72

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 12/01/2012

Required Date: 02/02/2012

Start Qty: 3.00

Required Qty: 3.00

NAS1149D0563J

Purchased

No

110

Each

5,090.000

8

24

NAS1149D0563.I

Washer

**

Location

Loc Qty

Loc Code

ST298

5090

118206

1098

118614

1000

119546

2000

119717

992

24

NAS1149D0663J

Purchased

No

110

Each

1,332.000

4

12

NAS1149D0663.I

Washer

**

Location

Loc Qty

Loc Code

ST298

1332

119075

1332

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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REFERENCE ONLY

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 206 A/B	D206-642-111
BELL 206 A/B	D206-642-113

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

ITEM	PART NUMBER	K10111	D206-642-111	D206-642-113
1	D206-651-041	1	1	1
2	D2652	16	16	16
3	D3413-1	1	1	1
4	D2661-1	2	2	2
5	D2662-1	2	2	2
6	D2712	10	10	10
7	D2884	2	2	2
8	D2885	2	2	2
9	AN3-41A	8	8	8
10	AN4C5A	1	1	1
11	AN4-6A	12	12	12
12	AN5-7A		8	
13	AN5-10A	4		4
14	AN5-11A	4		4
15	AN6-44A	2	2	2
16	NAS1149D0363J	8	8	8
17	NAS1149D0463J	24	24	24
18	NAS1149D0563J	8	8	8
19	NAS1149D0663J	4	4	4
20	MS21042-3 (OR L3)	8	8	8
21	MS21042-4 (OR L4)	12	12	12
22	MS21042-6 (OR L6)	2	2	2
23	NAS1149C0463R	1	1	1

C	ADDED ITEM COLUMN, ADDED ITEMS 13 & 14, QTY'S FOR ITEM 12 UPDATED.	AJS	11.11.10
B	ADD APPLICABILITY TO D206-642-113	AJS	11.09.19
A	NEW ISSUE	RF	00.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>140</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>EE</i>	K10111	SHEET 1 OF 1
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.	<i>140</i>	SADDLE KIT	NTS
DATE	11.11.10	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	